

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000370**Date Inspected:** 21-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** Michael Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Danny C. White (B89) is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/Fluor (ABF) for the purpose of witnessing Procedure Qualification Record (PQR) tests. On this date, the QA Inspector observed the following personnel present: Smith-Emery Company Quality Control (QC) Representative Certified Welding Inspector (CWI) Mr. Michael Johnson, ABF Representatives Mr. Tommy Gibson, Mr. Rick Clayborn and welder Mr. Dan Gordon.

At the beginning of the shift the QA Inspector observed the completion of welding of PQR test plate known as ABF-PQR-001-1B. This will be the second attempt of this PQR test plate. Welder Dan Gordon deposited weld passes (3) through (7) on this day. The Root weld (pass #1) and weld pass #2 were deposited on Monday 8-20-07. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. This PQR plate is being welded in the 1G position. The welders are using .072 inch diameter (1.8mm) Lincoln 232 E71T-8 (FCAW-S) process and utilizing a Bug-O Systems mechanical device that travels on a magnetic track. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated this date.

Later in the shift the QA Inspector observed welding of PQR test plate known as ABF-PQR-002-2B. This will be the second attempt to weld this PQR test plate. Welder Dan Gordon deposited the root weld pass and 370 millimeters of weld pass #2 before the end of the shift. Mr. Johnson monitored welding amperage, voltage and travel speed parameters. This PQR plate is being welded in the 3G position. The welders are using .072 inch diameter (1.8mm) Lincoln 232 E71T-8 (FCAW-S) process and utilizing a Bug-O Systems mechanical device that travels on a magnetic track. For specific welding parameters recorded during this PQR see Caltrans Welding Witness Report, TL-6032 generated upon completion of this PQR test plate.

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Summary of Conversations:

The QA Inspector observed the QC Inspector perform informational Ultrasonic Testing (UT) on the PQR plate known as ABF-PQR-001-1B and the QC Inspector informed the QA Inspector that no rejectable indications were found.

The QA Inspector performed a visual inspection on the PQR plate known as ABF-PQR-001-1B and informed the QC Inspector that a green tag with the Lot # B89-014-04 has been affixed to the face of PQR plate ABF-001-1B.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	White,Danny	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
